



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18588-PO
Job Sheet 183387



Part No: RBT18588-PO

Job Qty: 4 ea

Part Name: T/R Gearbox Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/17/18

Job Tracking No:

Due Date: 10/29/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBT18588 Rev. A IPP Rev. A 18.09.17 Now purchased DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	4 pcs		10/29/18	0.00	0.00	Purchasing		<i>[Signature]</i> OCT 24 2018
110	Packaging	4 pcs		10/29/18	0.00	0.00	Packaging2		<i>[Signature]</i> OCT 24 2018
120	QC	4 pcs		10/29/18	0.00	0.00	QC6		38
130	Packaging	4 pcs		10/29/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	4 Ea		10/29/18	0.00	0.00	QC21		<i>[Signature]</i> OCT 24 2018

Part Op 100 - Issue P/O: 041031 MANUFACTURE RBT18588 AS PER DWG Supplier: METEC Certificate of conformity is Descriptions: required

130 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG. *GA*

Sept 17, 2018 x 4 [Signature]

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18588P	T/R Gearbox Support	4 (1 ea)	100-Purchasing	<i>3120822</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT18588P	4	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 9/17/18 11:29 AM dart.Lussier.Patrick

Container No: S120823



Part: RBT18588

Job No: 183387

Serial No/Batch: S120823

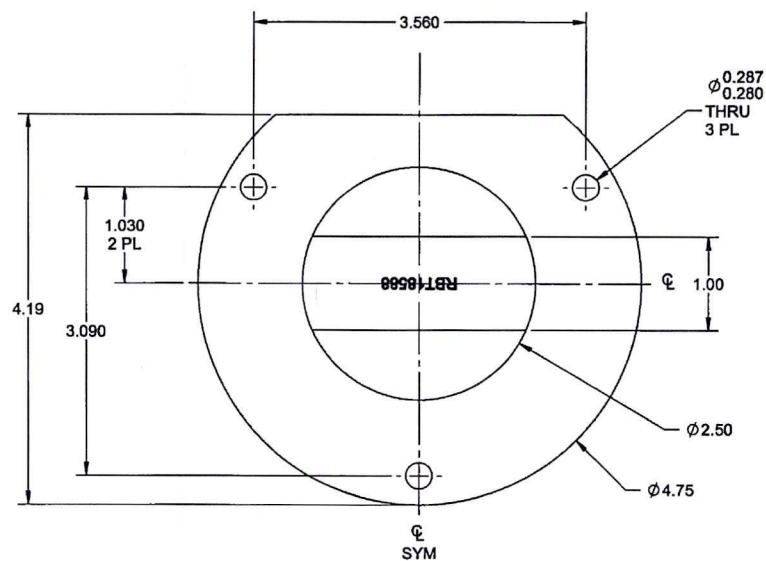
Revision: A

Inspector:

Exp Date:

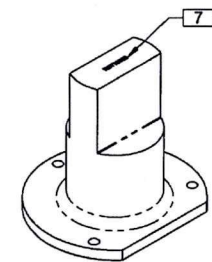
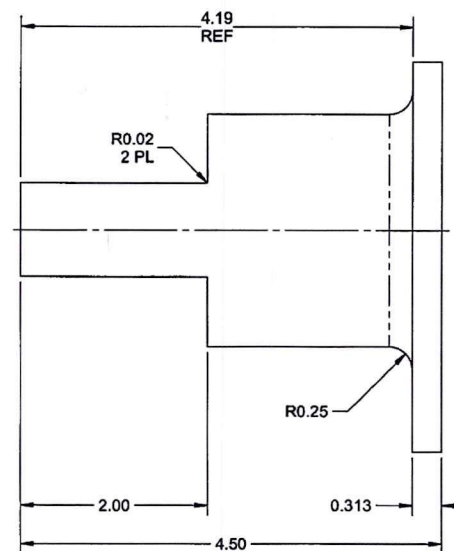
Instructions:

Date: 10/24/18



RBT18588 T/R GEARBOX SUPPORT

8



NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
 X.XX = $\pm 0.01"$ / $\pm 0.5"$
 X.XXX = $\pm 0.005"$ / $\pm 0.1"$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN
- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A NEW ISSUE		18-802	KPT
REV.	DESCRIPTION		ECN # BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFC	RBT18588	SHEET 1 OF 1
APPROVED	WY	TITLE	SCALE
DATE 9/12/2018		T/R GEARBOX SUPPORT	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041031**

Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: PO041031

PO Date: 9/17/18

Due Date: 10/29/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

E-MAILED
SEP 17 2018

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183307	D4885-1P			End Fitting : Various STC's receive pcs	Firmed	-	10/22/18	8 pcs	0 pcs	8 pcs	\$638.00/pcs	\$5,104.00
Line Item Note REV A													
2	183338	RBW109-3501-08-115P			Adapter, Landing Gear Shockstruts Nitrogen Change As Per Dwg RBW109-3501-08-115 Rev. 3	Firmed	-	10/29/18	1 Ea	0 Ea	1 Ea	\$498.00/Ea	\$498.00
Line Item Note REV 3													
3	183374	RBW109-3501-08-115P			Adapter, Landing Gear Shockstruts Nitrogen Change As Per Dwg RBW109-3501-08-115 Rev. 3	Firmed	-	10/29/18	2 Ea	0 Ea	2 Ea	\$498.00/Ea	\$996.00
Line Item Note REV 3													
4	183387	RBT18588P			T/R Gearbox Support	Firmed	-	10/29/18	4 Ea	0 Ea	4 Ea	\$477.00/Ea	\$1,908.00
Line Item Note REV A													
Grand Total:													\$8,506.00

DAS
38
9-89



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041031

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "P. Lussier", is written over the bottom right portion of the Order Notes section.

Plex 9/17/18 12:13 PM dart.Lussier.Patrick



Packing Slip 39261A

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

TEL: 613-384-1662 FAX: 613-384-2997

www.wejay.com

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA	
		41031		09/18/18		Best way	
CUSTOMER CODE ART				PROV. LIC. NO.		TERMS	
				Extra ☐ Exempt ☐			
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
8	0	8 ✓	End fitting as per drawing D4885, Rev. A Part Number: D4885-1P ✓ Job: 183307 ✓ Required by: October 22, 2018				
2	0	2 ✓	Adapter, landing gear, shockstruts, Nitrogen change as per drawing RBW109-3501-08-115, Rev. 3 Part Number: RBW109-3501-08-115P Job: 183374 ✓				
4	0	4 ✓	T/R gearbox support as per RBT18588, Rev. A Part Number: RBT18588P ✓ Job : 183387 ✓ Required by: October 29, 2018 RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <u><i>Chfpr</i></u>  Oct 18/18				
						H.S.T.	

ORDER: COMPLETE ☐
PARTIAL ☐**TOTAL**

CEIVED BY _____

% PER MONTH (18% PER ANNUM)
ARGED ON OVERDUE ACCOUNTSNO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace	DATE: Oct. 22, 2018		
	P.O.# 41031 line 3 ✓		
	WEJAY JOB# 39261		
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
RBT18588P ✓ 'End Fitting' ✓ Job: 183387 ✓	4 ✓	Machined complete per dwg req'ts. Anodized Red per dwg req'ts.	RBT18588 / rev. A
Note: 1) Material Test Cert . attached - ref. 'SCM' Lot# 201807538 (Wejay TN# 34457-1). 2) Anodizing C of C attached - ref. 'Graves Eng.' C of C# 10550016. 3) 1st article Inspection report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

DAS
38
9-89

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



Service Center Metals

5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS



OUR ORDER NUMBER	ITEM
953082	10

BILL TO
Thyssenkrupp Materials NA
SHIP TO
ThyssenKrupp Materials NA-Concord, ON
Quantity Certified 1,000 lbs 4 pcs

MANIFEST NUMBER
369158
CUSTOMER PO
5400400605
CUSTOMER PART NUMBER
ALRD00402

DIE NUMBER
RD0704
ALLOY / TEMPER
6061-T6511
DESCRIPTION
Lightning Rod Tite 4.750 +/- .012

DATE OF SHIPMENT
6/5/2018
SALESPERSON
D.Schroeder (Canada)

CERTIFICATION
ASTM-B221-14 StencilCont
SPECIFICATION
RoHS 2011/65/EU Compliant

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. Items produced and certified as 6061-T6511 also meet the requirements of 6061-T6.

All aluminum products supplied by Service Center Metals, LLC contain no functional mercury. Neither mercury nor its compounds are used in the manufacture of aluminum products at our facility. Furthermore, aluminum products supplied by Service Center Metals have not, to the best of our knowledge, contacted any source of mercury.

SCM is ISO 9001-2015 certified

This product is RoHS-2, REACH, and DFARS compliant.

Mechanical Properties

Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)		Yield Strength (KSI)		Percent Elongation	
			min	max	min	max	min	max
1	201807538	4/28/18	51.10	51.10	47.40	47.40	18.60	18.60

REF "DART" P.O.#41031 LINE 3
PART# RBT18588P



Oct 18/18

Chemical Composition for Aluminum Alloy 6061

Cast #	Lot No.	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	AL	Others		Melt Source:
												Each	Total	
001J180304B	201807538	6061	0.74	0.37	0.33	0.10	0.93	0.11	0.06	0.03	97.33	0.05	0.15	United States of America
001J180305A	201807538	6061	0.75	0.38	0.33	0.10	0.91	0.11	0.07	0.03	97.32	0.05	0.15	United States of America
001J180412A	201807538	6061	0.75	0.37	0.31	0.10	0.90	0.10	0.08	0.03	97.35	0.05	0.15	United States of America

SCM products are melted and extruded in the USA

Calvin J. Wiggins, Director of Quality & Technical Services

Print Date: 6/5/2018

Rev 3/14/2018

From: TK Materials CA, Ltd.
Cust. WEJAY MACHINE PRODUCTS CO LTD
CstAr 34457
Wgt.: 44 LB

Del.: 2406277366

Date 10/04/2018

TN34457-1
Job #39261
rec'd Oct 5/18

Thomas Schroeder

Graves Engineering & Finishing

760 Burnett St.
Kingston, ON K7M 5W3
Ph: (613)634-9910

CERTIFICATION OF COMPLIANCE

WEJAY MACHINE PRODUCTS CO LTD	PO 0000034431
600 O'CONNOR DRIVE	OCTOBER 19, 2018
KINGSTON ON K7P 1N3	CoC# 10550016

ROHS 2011/65/EU COMPLIANT PROCESS

GENERAL SPECIFICATION

MIL-A-8625F

TYPE 2 CLASS 2

COLOUR: RED ALLOY: 6061

PART # VARIOUS

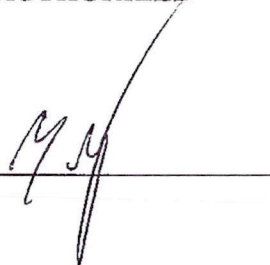
OF PIECES 4

CERTIFICATION

WE CERTIFY THAT THE PARTS FURNISHED ON THIS ORDER ARE
MADE IN COMPLIANCE WITH DRAWINGS AND OR
SPECIFICATIONS OF TYPE AND CLASS, SUBMITTED BY THE CUSTOMER.

RECORDS SUBSTANTIATING THE ABOVE STATEMENTS ARE
AVAILABLE IN OUR FILES FOR INSPECTION BY AUTHORIZED
PERSONNEL

Approved Signature



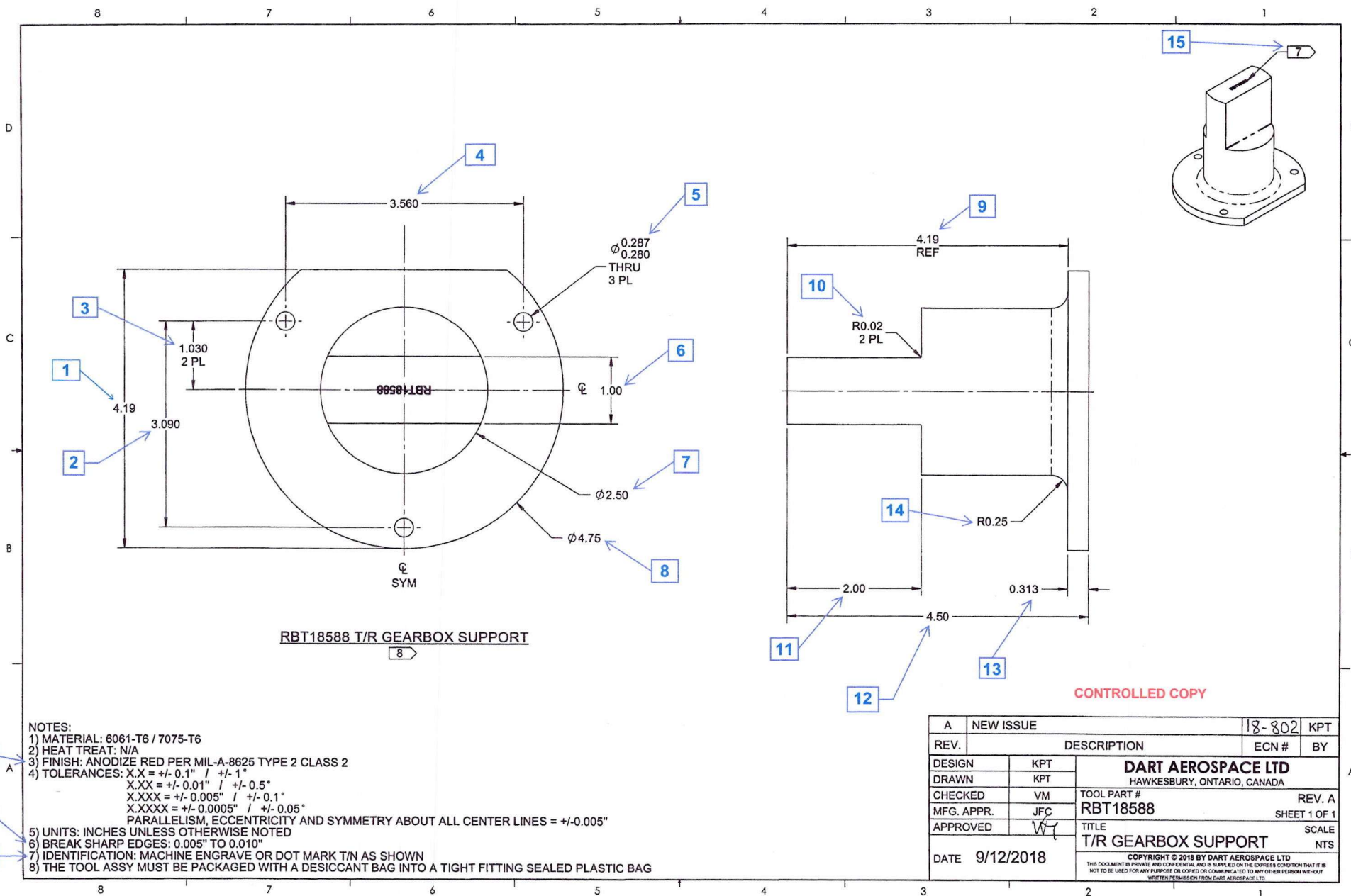
DA:
36
9-P

REF. 'DART' P.O. #41031 LINE 3

PART # BBT18588P



OCT 22/18





600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 39261

PAGE: 1 of 1

CUSTOMER: DART Aerospace

CUST. P.O.# PO

PART No. RBT 18588

DESCRIPTION: T/R Gearbox Support

DWG No. RBT18588

REV. A

E.C.O. -

MATERIAL: Aluminum Alloy 6061 T6

INSPECTOR:

CLIFF SMITH

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
-

N.C.R.#

DATE:

Oct 18/18

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	4.19		±.005	C8	4.189	1	ACCEPTED
2	3.090		±.005	C8	3.091	1	"
3	1.030		±.005	C7	1.032	1	"
4	3.560		±.005	D6	3.561	1	"
5	Ø 0.287/ .280		-	C5	Ø.282 TYP.	1	"
6	1.00		±.01	C5	1.000	1	"
7	Ø 2.50		±.01	B5	Ø 2.500	1	"
8	Ø 4.75		±.01	B5	Ø 4.745	1	"
9	4.19 ref.		±.01	C3	4.185	1	"
10	R 0.02	2 pl.	±.01	C3	R.025 TYP.	1	"
11	2.00		±.01	B3	1.999 TYP.	1	"
12	4.50		±.01	B3	4.497	1	"
13	0.313		±.005	B2	.3115-.312	1	"
14	R 0.25		±.01	B3	R.250	1	"
15	Part Identified per note 7	As indicated	RBT 18588	A8, C6	PASSED	1	"
16	Deburring per note 6		.005-.010	A8	PASSED	1	"
17	Red Anodize per note 3	MIL-A-8625 type 2 class 2		A8			